

W/O: 85033

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2195-1 PAR #: _____ Fault Category: Sm 7ab WS NCR: Yes No DQA: John Date: 12/06/11
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: C Date: 12/6/12

NCR: 12-1487

WORK ORDER NON-CONFORMANCE (NCR) 12.02

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12-06-01	120	over all length to short, process error RC operate error Q4 x1	S ASIAZ 12/06/01	Scrap + Destroy (Don't replace)	Jm 12-06-01	m/h 12-06-01	S ASIAZ 12/06/01	S 12/06/01

NOTE: Date & initial all entries

Work Order ID 85033

May-31-12 3:11:52 PM

85033

Page 2

Item ID: D2195-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket

Start Date: 31/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	Bend as per dwg D2195								
140		0.00							
140	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
150		0.00							
150	Identify as per dwg & Stock Location: <u>GA</u>								
Packaging	Memo	0.00							
Packaging									

②

8/12/06/04

5/12/00/01

②

2x

8/12/06/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85033

May-31-12 3:11:52 PM

85033

Page 3

Item ID: D2195-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket

Start Date: 31/05/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***QC: Date: SPC (Y/N): Date: Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept
Qty Reject
Qty Reject
Number Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/6/7
ME
12-06-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-31-12 3:11:57 PM

Page 1

Work Order ID: 85033

85033

Parent Item: D2195-1

D2195-1

Parent Item Name: Bracket

Start Date: 31/05/2012

Required Date: 14/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-07-24 new issue ec verified by:dd
IPP Rev:B 09-01-28 rev.d as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

No

**

**

B# 120877.

0.558 5F

JM
12-5-31

M304 5166A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM No.	QTY	PART NUMBER	DESCRIPTION
1	X	D2195	BRACKET ASSEMBLY
7	1	D2195-1	BRACKET
8	1	D2195-2	BRACKET
9	1	D2195-3	SPACER
15	6	MS20470AD4-14	RIVET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 05033 MLJ

12/05/31

RELEASED
29/07/13/11/8

NOTES:

- 1) MATERIAL:
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2195" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.26 lbs

D	RE-DESIGN. REF NCR 08-110.	AJS	08.11.25
C	REDRAW: D2195-3 NOW 0.5" THICK	CP	03.05.28
B	RE-DESIGN	JB	93.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<u>[Signature]</u>	DRAWING NO.	REV. D
MFG. APPR.	<u>[Signature]</u>	D2195	SHEET 1 OF 3
APPROVED	<u>[Signature]</u>	TITLE	SCALE
DE APPR	<u>[Signature]</u>	BRACKET	NTS
DATE	08.11.25	<small>COPYRIGHT © 1993 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR RE-OR COMMERCIALISED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval- QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

25033

D2195-2
BRACKET

D2195-1
BRACKET

D2195-3
SPACER

MS20470AD4-14
RIVET
6 PL

D2195 BRACKET ASSEMBLY

RELEASED
27/01/15

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	J	DRAWING NO.	REV. D
MFG. APPR.	E	D2195	SHEET 2 OF 3
APPROVED	AM	TITLE	SCALE
DE APPR.	AM	BRACKET	NTS
DATE	08.11.25	COPYRIGHT © 1993 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OF COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

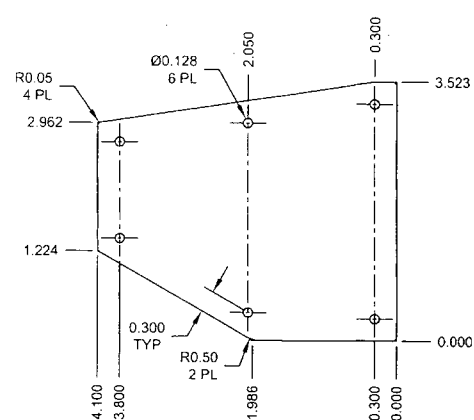
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

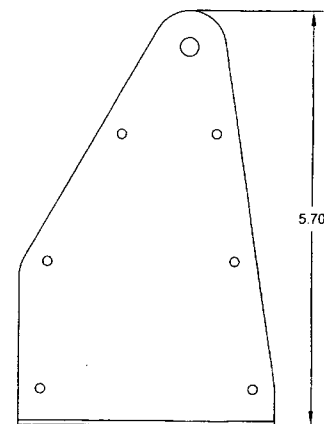
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2195-3 SPACER



1. *Journal of the American Medical Association*, 1997; 278: 1039-1044.

D2195-1 BRACKET
MAKE FROM D2195-1F

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. <u> </u> D2195 TITLE BRACKET SCALE NTS COPYRIGHT © 1993 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE LOANED FOR AN UNAPPROVED OR UNCONTROLLED COPY TO ANY OTHER PERSON OR UNIT. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM.</small>
DRAWN	AJS	
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	08.11.25	

RELEASED
09/01/15 JWW

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: E5033
Description: Bracket		Part Number: D2195-1
Inspection Dwg: D2195 Rev: 0		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.257"	+0.006 -0.001	0.257"	✓		✓	mm01
Ø 0.128"	+0.005 -0.001	0.128"	✓		✓	
Ø 0.203"	+0.005 -0.001	0.203"	✓		✓	
0.375"	+/- 0.010"	0.380"	✓		✓	
1.200"	+/- 0.010"	1.204"	✓		✓	
2.390"	+/- 0.010"	2.398"	✓		✓	
4.068"	+/- 0.010"	4.068"	✓		✓	
5.890"	+/- 0.010"	5.898"	✓		✓	
7.090"	+/- 0.010"	7.098"	✓		✓	
7.590"	+/- 0.010"	7.599"	✓		✓	
0.300"	+/- 0.010"	0.310"	✓		✓	
2.323"	+/- 0.010"	2.328"	✓		✓	
0.336"	+/- 0.010"	0.342"	✓		✓	
1.273"	+/- 0.010"	1.281"	✓		✓	
2.211"	+/- 0.010"	2.216"	✓		✓	
3.149"	+/- 0.010"	3.153"	✓		✓	
3.524"	+/- 0.010"	3.533" 3.582"	✓		✓	
R 0.25"	+/- 0.030"	0.25"	✓		RG	
R 0.50"	+/- 0.030"	0.50"	✓		RG	
4.140"	+/- 0.010"	4.150"	✓		✓	
2.390"	+/- 0.010"	2.397"	✓		✓	
0.064"	+/- 0.010"	0.060"	✓		✓	

Measured by: JM	Audited by: M/M	Prototype Approval:	N/A
Date: 12-5-31	Date: 12-06-01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	